

# Work Order ID 51386

August 20, 2009 3:35:19 PM



Page 1

Item ID:	D3508-3	Accept		Setup	Start	
Revision ID:	C				Stop	
Item Name:	Wearplate					
Start Date:	08/24/2009	Start Qty:	12.00	Cust Item ID:		
Required Date:	08/28/2009	Req'd Qty:	12.00	Customer:		
Reference:						

Approvals:	Process Plan:	<u>MF</u>	Date:	<u>09-08-20</u>	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3508	Rev C

100		0.00							
	FLOW WATER JET								
Waterjet	Memo	0.00							
FLOW CNC Waterjet	1-Cut as per Dwg D3508 Deburr if necessary		<input type="checkbox"/> Dwg Rev: <u>C</u>	<input type="checkbox"/> Prog Rev: <u>C</u>					

IB 9-9-15

(12)

110		0.00							
	QC2- Inspect parts off machine FAI/FAIB								
QC	Memo	0.00							
Quality Control									

IB 9-9-15

120		0.00							
	QC8- Inspect parts - second check								
QC	Memo	0.00							
Quality Control									

> Sorlorlu

(12) /

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 51386

August 20, 2009 3:35:19 PM



Page 2

Item ID: D3508-3

Accept



Setup Start



Revision ID: C

Stop



Item Name: Wearplate

Start Date: 08/24/2009 Start Qty: 12.00



Cust Item ID:

Required Date: 08/28/2009 Req'd Qty: 12.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev. Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130

0.00



NC BRAKE

Brake NC

Memo

0.00

Brake NC

1-Form on brake using DT8326 and DT8261 as per Dwg D3508 2-Form joggle as per Dwg D3508 Using DT8158 SB 09/09/16

12

0

140

0.00



QC5- Inspect part completeness to step on W/O

QC

Memo

0.00

Quality Control

278 09/09/16

412

0

150

0.00



Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

Powdercoat

Memo

0.00

Powder Coating

START TIME: 11:30am FINISH TIME: 12:00pm OVEN TEMPERATURE: 320°F

11109091

278 09/09/16

112

0

W/O:		WORK ORDER CHANGES					
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**NOTE:** Date & initial all entries

# Picklist Print

August 20, 2009 3:35:19 PM

Page 1  
/

Work Order ID: 51386



Parent Item: D3508-3RevC



Parent Item Name: Wearplate


Start Date: 08/24/2009

Required Date: 08/28/2009

Comments:

Start Qty: 12.00

Required Qty: 12.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M304S20GA 		Purchased	No			100	sf	63.3940	9.2716			
304/316 .040 Sheet												

B 99-15

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

63.39404737

110076

31.73

111571

31.6640474

112567

112567

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries



<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 251 386
<b>Description:</b> Wearplate		<b>Part Number:</b> D3508-3
<b>Inspection Dwg:</b> D3508	<b>Rev:</b> C	<b>Page 1 of 1</b>

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
2.063	+/-0.010	2.060	✓			
2.813	+/-0.010	2.810	✓			
0.375	+/-0.010	0.375	✓			
5.625	+/-0.010	5.623	✓			
33.750	+/-0.010	33.748	✓			
37.13	+/-0.030	37.125	✓			
Ø0.188	+0.005/-0.001	.190	✗			
0.300	+/-0.010	.303	✗			
0.300	+/-0.010	.301	✗			
0.038	+/-0.010	.035	✗			

<b>Measured by:</b> EB	<b>Audited by:</b> J	<b>Prototype Approval:</b>	N/A
<b>Date:</b> 9-9-15	<b>Date:</b> 09/09/16	<b>Date:</b>	N/A

Rev	Date	Change	Revised by	Approved
A	08.04.15	New Issue	KJ/DD	EB

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

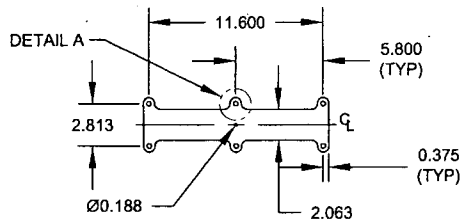
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Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

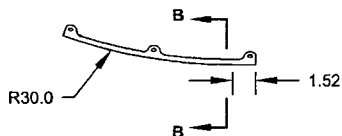
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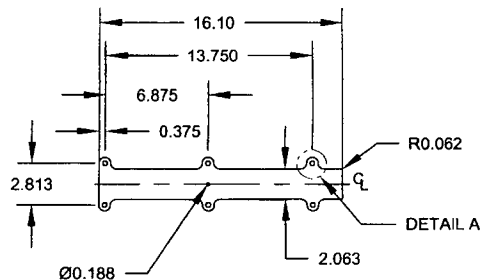
#51386  
MP  
09-08-20



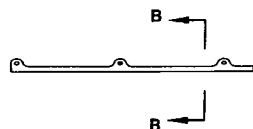
**D3508-1 FLAT PATTERN**



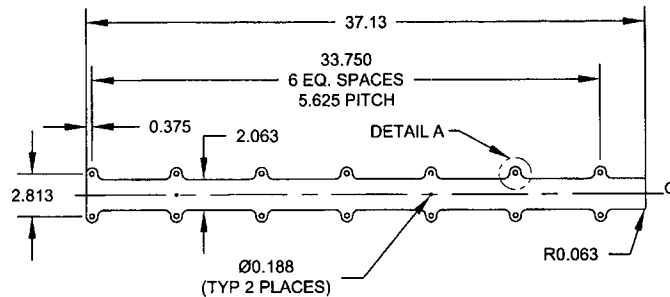
**D3508-1 BENDING DETAIL**  
(MAKE FROM D3508-1F)



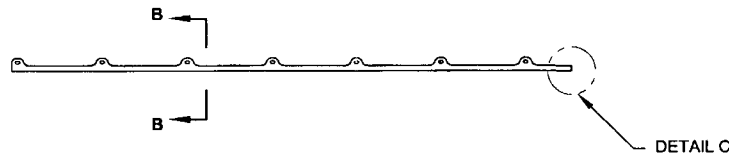
**D3508-7F FLAT PATTERN**



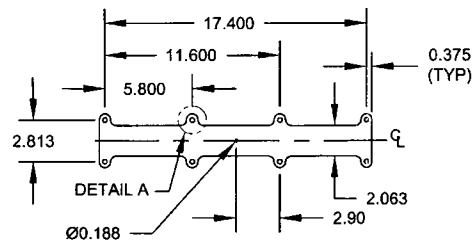
**D3508-7F BENDING DETAIL**  
(MAKE FROM D3508-7F)



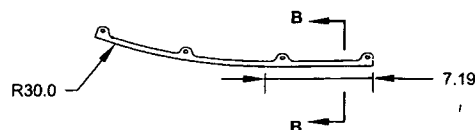
**D3508-3 FLAT PATTERN**



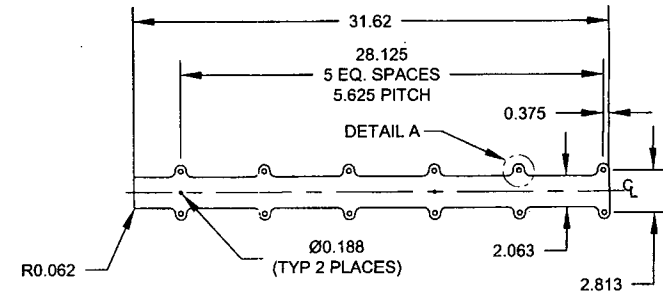
**D3508-3 BENDING DETAIL**  
(MAKE FROM D3508-3F)



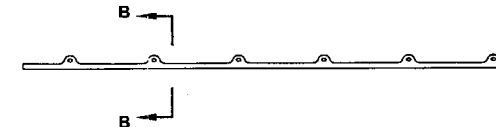
**D3508-9F FLAT PATTERN**



**D3508-9F BENDING DETAIL**  
(MAKE FROM D3508-9F)



**D3508-5 FLAT PATTERN**



**D3508-5 BENDING DETAIL**  
(MAKE FROM D3508-5F)

**NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK)  
(REF. DART MATERIAL SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) WELD PER DART QSI 004
- 4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: 0.005 TO 0.015
- 7) IDENTIFICATION: NONE
- 8) WEIGHT: D3508-1 - 0.47 lbs, D3508-3 - 0.95 lbs, D3508-5 - 0.77 lbs,  
D3508-7 - 0.39 lbs, D3508-9 - 0.45 lbs, D3508-11 - 0.64 lbs  
D3508-13 - 0.25 lbs

**RELEASED**  
07-11-16

C	ADD -9/-11/-13 MOVE TAB OUTBOARD (2.813 WAS 2.733) CHANGE DRAWING FORMAT	PH	07.04.20
B	CHANGE STAINLESS STEEL, WIDEN	PH	06.10.27
A	NEW ISSUE	PH	06.04.21
REV.	DESCRIPTION	BY	DATE
DESIGN	244	<b>DART AEROSPACE USA, INC</b>	
DRAWN	244	PORT HADLOCK, WA	
CHECKED	140	DRAWING NO.	REV. C
MFG. APPR.	140	D3508	SHEET 1 OF 2
APPROVED	140	TITLE	SCALE
DE APPR.	140	WEARPLATE	1:8
DATE	07.04.20	COPYRIGHT © 2007 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL. AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

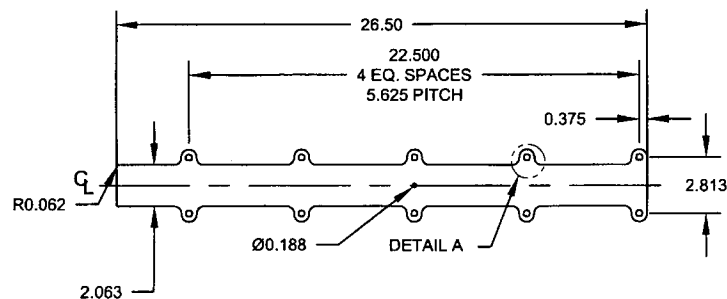
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

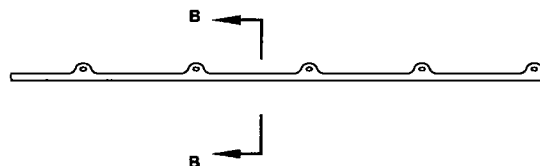
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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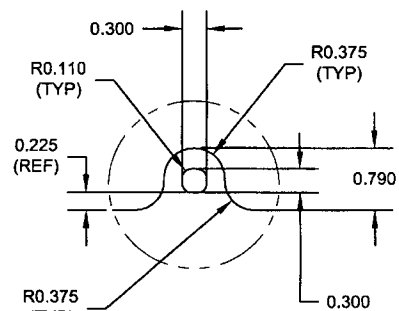
**NOTE:** Date & initial all entries



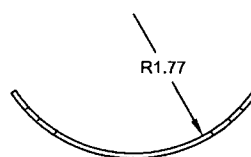
**D3508-11F FLAT PATTERN**



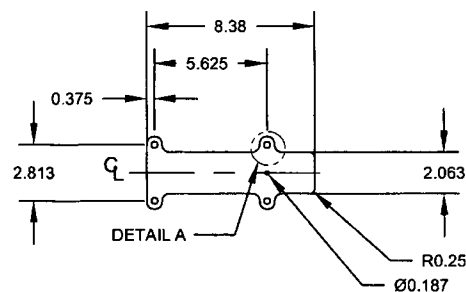
**D3508-11 BENDING DETAIL**  
(MAKE FROM D3508-11F)



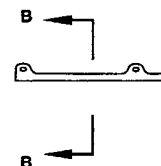
**DETAIL A**  
(SCALE 2:3)



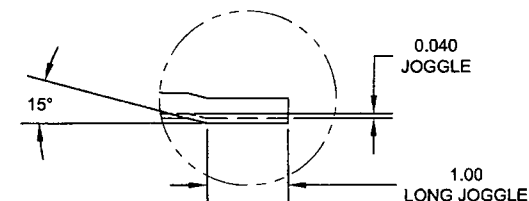
**SECTION B-B**  
(SCALE 2:3)



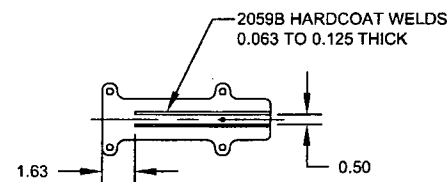
**D3508-13F FLAT PATTERN**



**D3508-13 BENDING DETAIL**  
(MAKE FROM D3508-13F)



**DETAIL C**  
(SCALE 1:2)



**D3508-13 WELDING DETAIL**

51386

RELEASED  
07-11-14

DESIGN	PH	<b>DART AEROSPACE USA, INC</b>	
DRAWN	PH	PORT HADLOCK, WA	
CHECKED	PH	DRAWING NO.	REV. C
MFG. APPR.	PH	D3508	SHEET 2 OF 2
APPROVED	PH	TITLE	SCALE
DE APPR.	PH	WEARPLATE	1:6
DATE	07.04.20	<small>COPYRIGHT © 2007 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE, OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

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